

Work Order ID 141814

141814

Page 1

Wednesday, April 27, 2016 10:32:40 AM

Item ID: D2622-120C Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Extrusion
 Start Date: 4/29/2016 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 5/11/2016 Req'd Qty: 120.00 ***120*** Customer:

Reference: DAS
 Approvals: Process Plan: 13 Date: APR 26 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2622	Rev C1

100	PURCHASING	0.00							DAS
100									13
Purchasing	Memo	0.00							9-89
Purchasing	Issue P/O: <u>31369</u> a) Extrude as per Dwg D2622 Rev. Cb)								
	Material: 6061-T6 (QQ-A-200/8)c) Minimum yield tensile strength = 35								
	ksid) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation =								
	8%f) Order at 120" longg) Bon L Canada Inc.								

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	2.40							
Packaging	Ensure material certification is attached								

120	QC18 In-Coming Inspection Material	0.00							
120									
QC	Memo	0.00							
Quality Control	Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester								

120 APR 26 2016 DAS

136x 80/605-26

(135) 1606-06 PD

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>Hall</u> WA03 Memo LOCATION : HALL	0.00 1.20				<u>120</u>	<u>CPC</u>	<u>16-06-14</u>	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 12.00						<u>16/6/15</u>	<u>Jim 16/06/15</u>

Picklist Print

Wednesday, April 27, 2016 10:32:38 AM

Page 1
T

Work Order ID: 141814

141814

Parent Item: D2622-120C

D2622-120C

Parent Item Name: Step Extrusion

Start Date: 4/29/2016

Required Date: 5/11/2016

Start Qty: 120.00

Required Qty: 120.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120CP *D2622-120CP* Extrusion		Purchased	No			110	Each	0.0000	1	120			

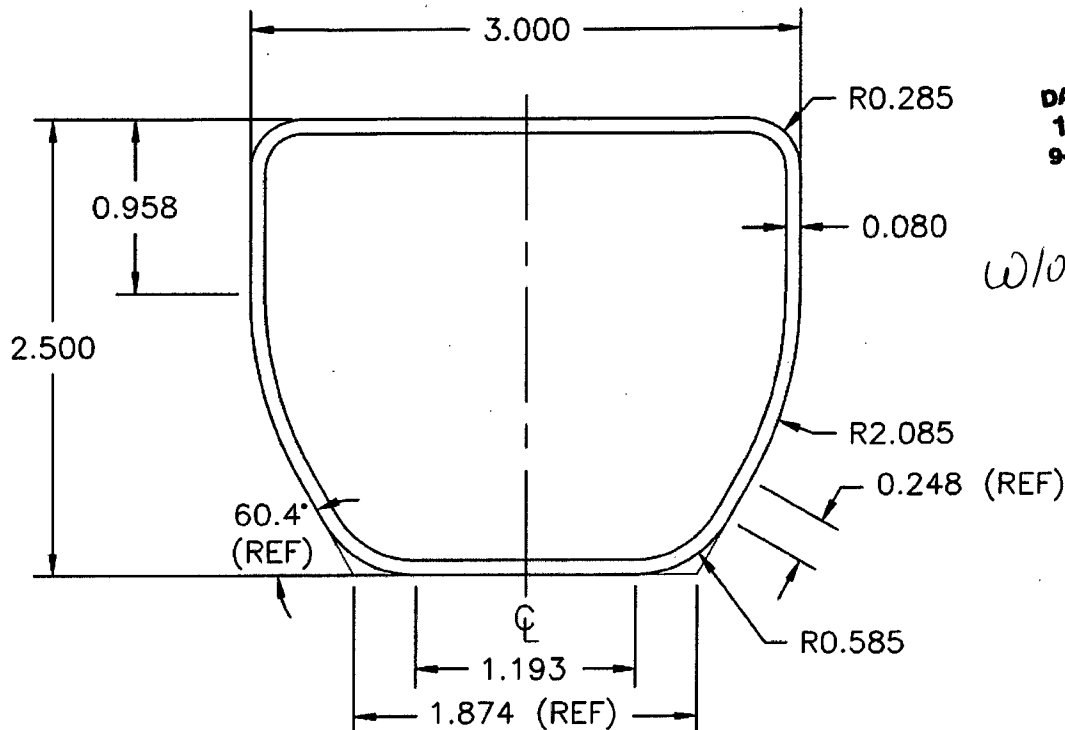
**

130
130x 8p/605-26



DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	CP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO31369

Purchase Order Date 2/16/2016

PO Print Date 5/6/2016

Page Number 1 of 2

Order From : VC-BON001
SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905-427-6550	Customer POID	
Vendor Fax	905-427-2246	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	CAD
		FOB	Destination-Collect
Ship Method	Yours ppd		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
2	D2622-120CP	Extrusion	5/11/2016 Yes 5/11/2016	120.00 Each	\$2,418.62
EXTRUDE AS PER DWG D2622 REV. C B141814					
EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS					
Line Total:					\$2,418.62
5	71475-45	D2600-1-120CP EXTRUSION	4/28/2016 Yes 4/28/2016	-132.00 Each	(\$2,440.68)
Line Total:					(\$2,440.68)

Rec'd 130x
8p/6-05-26

5/2/2016



Signature
aluminum
CANADA INC.

1850 Clements Road, Pickering Ontario, Canada L1W 3R8 INVOICING AND COMPANY LOCATION

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

PACKING LIST

ACCT# 46024

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST DATE / DATE DU
05-24-16

PACKING LIST NUMBER / N° DE
026343

SALES ORDER NUMBER / N° DE COM
123476

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	MCGILLION	042		R. BLAIS
CUSTOMER ID / ID DU CLIENT	ORDER DATE / DE LA COM	CUSTOMER PO NUMBER / CLIENT PO Nombre	JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES
46024	04/27/16	PO31369 REPLACEMENT BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 026343	CARRIER / TRANSPORTEUR MCGILLION	G.ATTENBOROU
				M2A

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	1,094	LB		DAA-897123-2	6061 T6		3	1,195	1,142	LB	
	496	KG		D2622-120CP	120.0000 IN			542	518	KG	
	120	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			130	PC	

						865535 / 310822	1	448	430		49 PC
						865535 / 310823	1	448	430		49 PC
						865535 / 310824	1	300	282		32 PC

SP/6-05-26

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards set of 1923 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

3	1,195	1,142	LB
	542	518	KG
		130	PC
TOTALS			



signature
aluminum
CANADA INC

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD.
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No.	Sales Order	Page
05/22/2016	5386995	123476	1
Cust PO	B/L No	Lot	Date
31369 REPLACEMENT	026343	865535	05/24/16

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP
Gross Weight	1,195 LBS		
Net Qty	1,142 LBS	130 PCS	3 PKGS
Specification	AMS-QQ-A-200/8 & ASTM B221-08		

Mechanical Tests:

DAS
9
9-89

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
313.1 / 45.4	282.8 / 41.0	10.8	N/A	91

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.63	0.25	0.22	0.06	0.89	0.07	0.04	0.02	0.01	0.00

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc



ISO 9001/TS16949 Registered Company

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